

Work Order ID 80292

80292

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February-16-12 10:28:52 AM

Item ID: D3391-021 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Tube Assembly
 Start Date: 16/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 01/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								
100		0.00							
100	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020								
110		0.00							
110	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021								
120		0.00							
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

DC 12/03/02

DD 12-3-1

6.685 BE 12/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	HAAS CNC VERTICAL MACHINING #1								
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>E</u> Identify as D3391-1 2-Deburr								
140		0.00							
140	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	Drill X1 Aft cap as per Dwg D3391 .1875" dia								

W/O:		WORK ORDER CHANGES					
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N900040100

Setup Start *NS1*

Stop. ***NS2***

Start Date: 16/02/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 01/03/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

160

QC

Memo

0.00

Quality Control

170

QC8- Inspect parts - second check

0.00

170

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

180

Skidtubes

Skidtubes

Skidtubes

Memo

1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
 (ONLY DRILL HOLES MARKED "A")

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

NO WEARPLATE HOLES ARE TRANSFER DRILLED

0.00

0.00

0.00

0.00

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

1 of 12-36

De 12/03/06

(Signature)

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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Chemical Conversion Coat per QSI005 4.1	0.00							
200									
HandFinish	Memo	0.00							
Hand Finishing									
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control									
220	Skidtubes	0.00							
220									
Skidtubes	Memo	0.00							
Skidtubes	1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: <u>M120666</u> exp. date: <u>13-01-78</u> cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary								

① 7/6/12 2-3-7

① SAO 12-03-07

① SAO 12-03-07

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230 QC5- Inspect part completeness to step on W/O 0.00

230

QC

Memo

0.00

Si 7/1-3/09

Quality Control

235 Pressure Wash per QSI005 4.3 0.00

235

HandFinish

Memo

0.00

Hand Finishing AND REALODINE AS PER PAR09-043

IX of M. 12/03/09

240 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

240

Powdercoat

Memo

0.00

Powder Coating

START TIME: *8h45*
 OVEN TEMPERATURE: *320°F*
 FINISH TIME: *9h15*

1 Q (AP) 12/03/12

m120222

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

**Insp.
Stamp**

0.00

250

QC

Memo

0.00

Quality Control

0.00

255

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

**** install D3591-1 spacer as per DSI9364 and wearplate as per DWG ****

QC5- Inspect part completeness to step on W/O

0.00

257

QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: <u>wlo</u>	0.00	D412-742-043/B81091						
260									
Packaging	Memo	0.00							
Packaging									
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/26
 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 80292

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Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM
 IPP B06.02.10Dwg rev.D ecn 773 EC
 IPP C06.05.02Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-051 *D4095-051* Wearpad Assembly		Manufactured	No			255	Each	15.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				15					
				78821				15					
D6013-047 *D6013-047* Skidtube Material		Manufactured	No			100	Each	127.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				127					
				72505				127					
D3670-4-200 *D3670-4-200* SPACER		Manufactured	No			220	Each	99.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				99					
				72851				7					
				77500				32					
				78606				60					

**

ysl 12/03/16

**

DL 12/03/01

**

SAD 12-03-07

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3401-041 Manufactured No

255 Each 7.0000 1 1

D3401-041

Tow Cap Assembly

**

1378990 (x1) Hl n103116

Location

Loc Qty

Loc Code

FP002

7

76211

7

AN960C10L

NAS1149C0332

Purchased

No

255 Each 0.0000 10 10

R

***AN960C10L *** ✓

washer

**

M120648 (x10) Hl n103116

AN3C4A

Purchased

No

255 Each 3,439.000 10 10

AN3C4A

BOLT

**

M120930 (x10) Hl n103116

Location

Loc Qty

Loc Code

ST350

3439

117313

2

117688

5

117872

10

118112

16

118451

2

119749

10

120187

2000

120423

394

120521

1000

W/O:		WORK ORDER CHANGES					
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D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

255 Each 924.0000 4 4

D3672-1

Phenolic Washer

** 44 n103116

Location

Loc Qty

Loc Code

FP001

288

66821

288

44

ST060

636

72229

136

76277

500

AELS-1032-225

Purchased

No

255 Each 0.0000 10 10

AFI S-1032-225 ✓

INSERT

A654-1032-225

** 1120410 Crid 24 n102116

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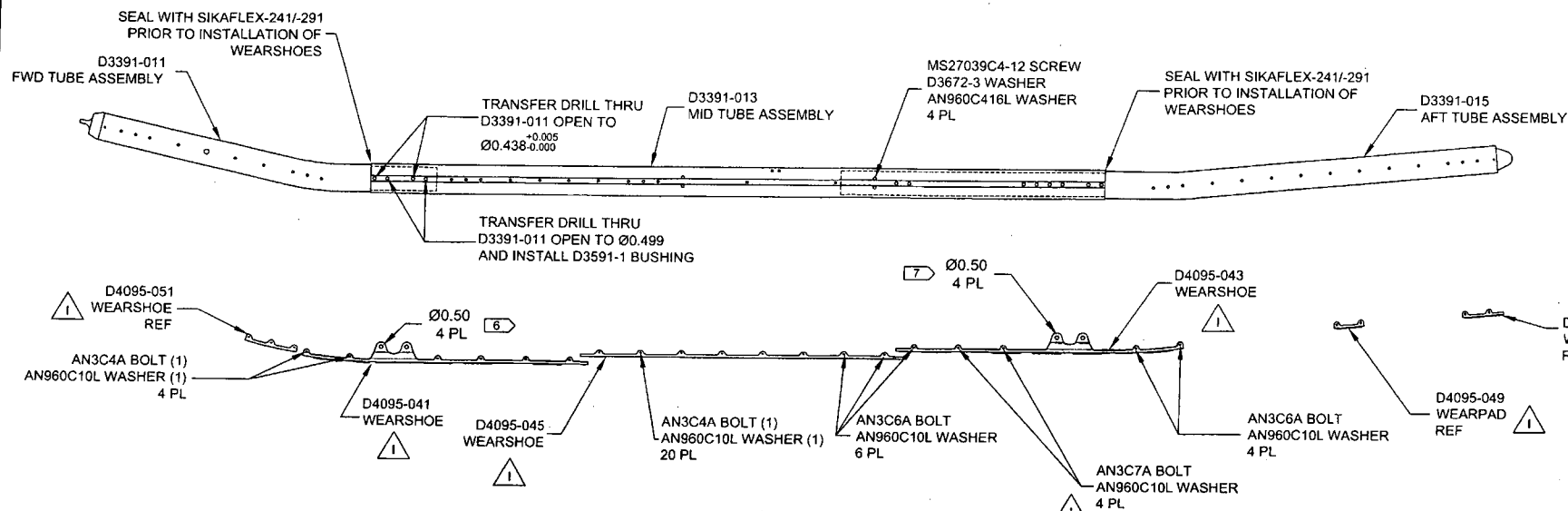
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D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

SHOP COPY

RETURNS TO

FOR INFO

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO 80292 H.C.J.

12/02/16

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04
ECN# H-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 0.438 DIM WAS 4 PL. ADDED 0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 0.438 DIM WAS 4 PL. ADDED 0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

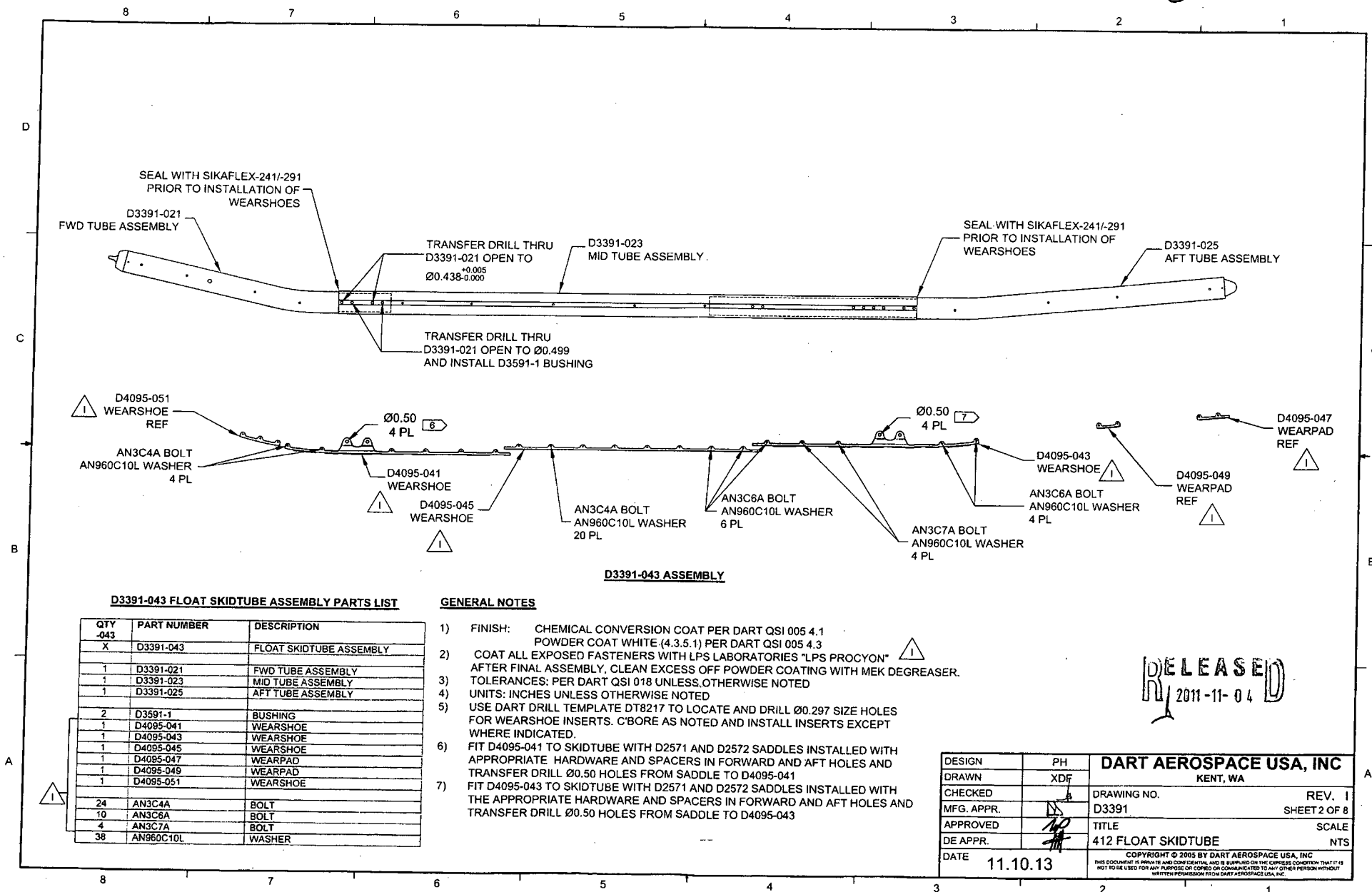
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

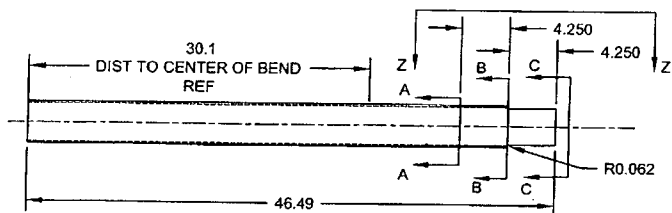
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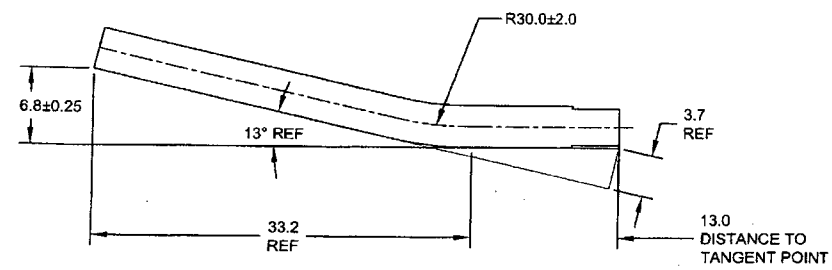
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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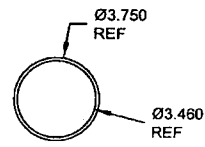
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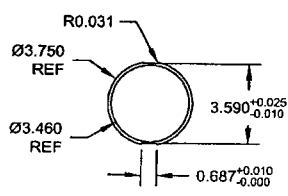
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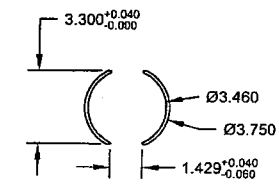
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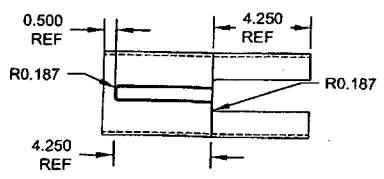
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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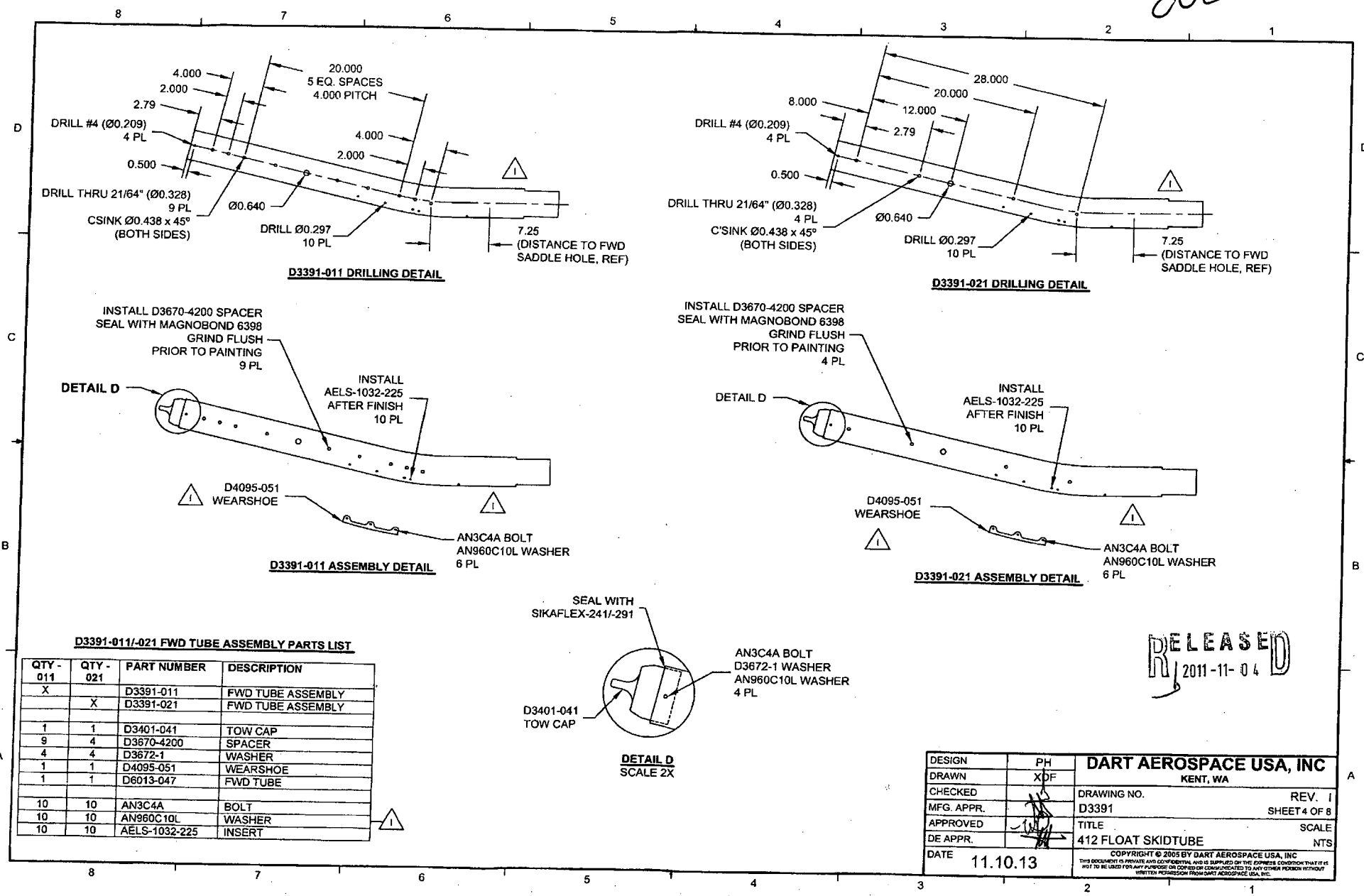
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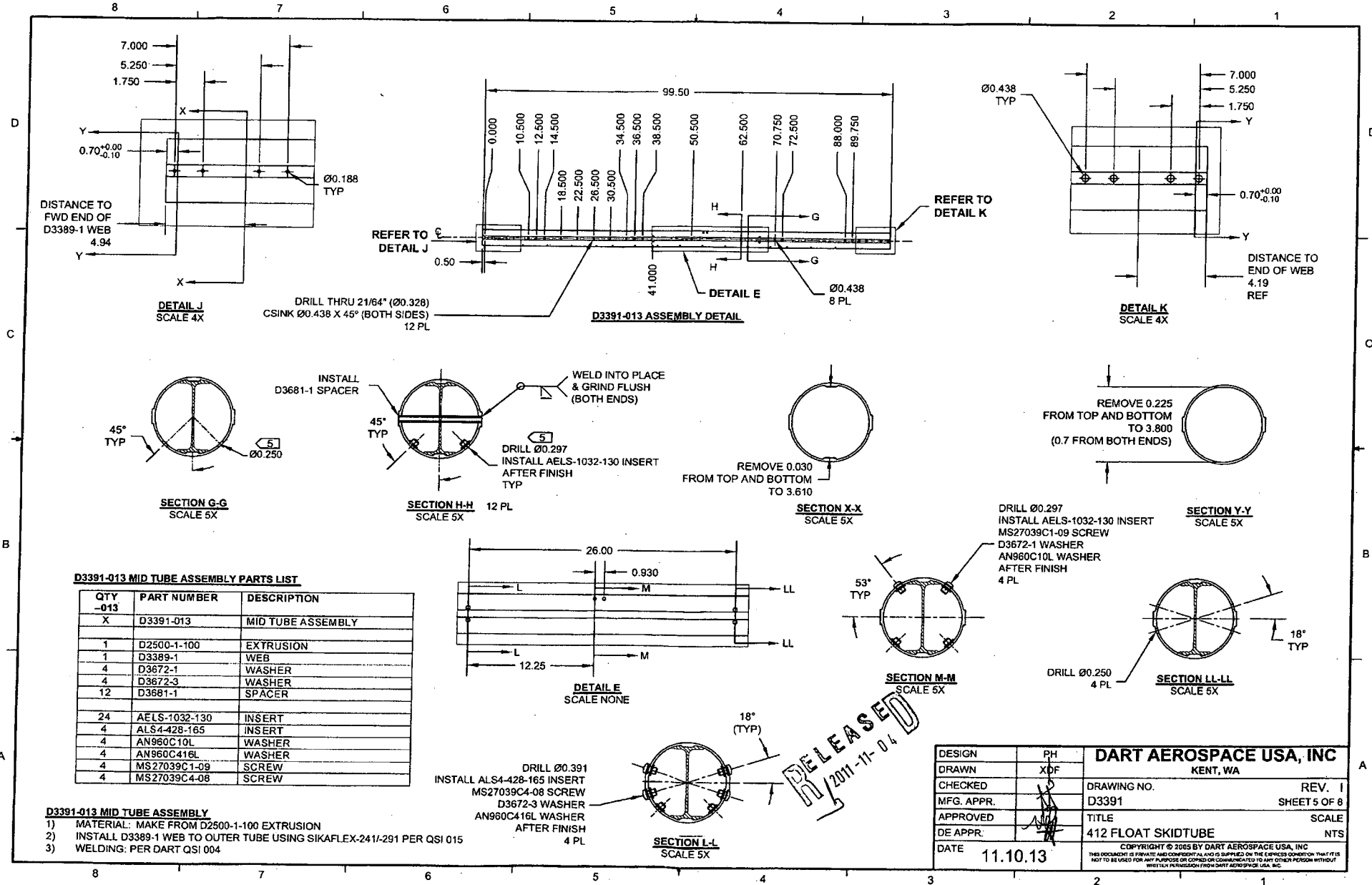
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



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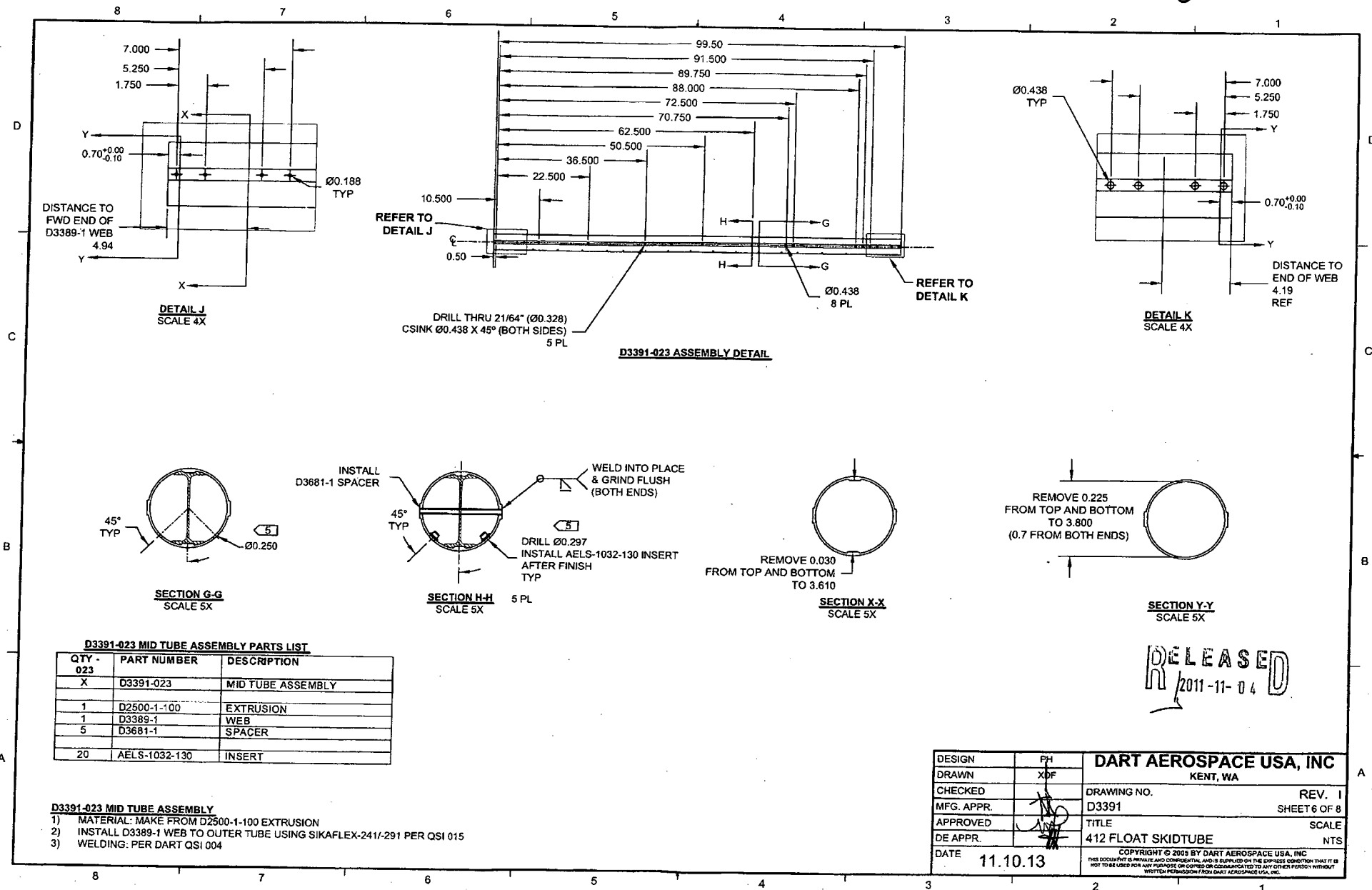
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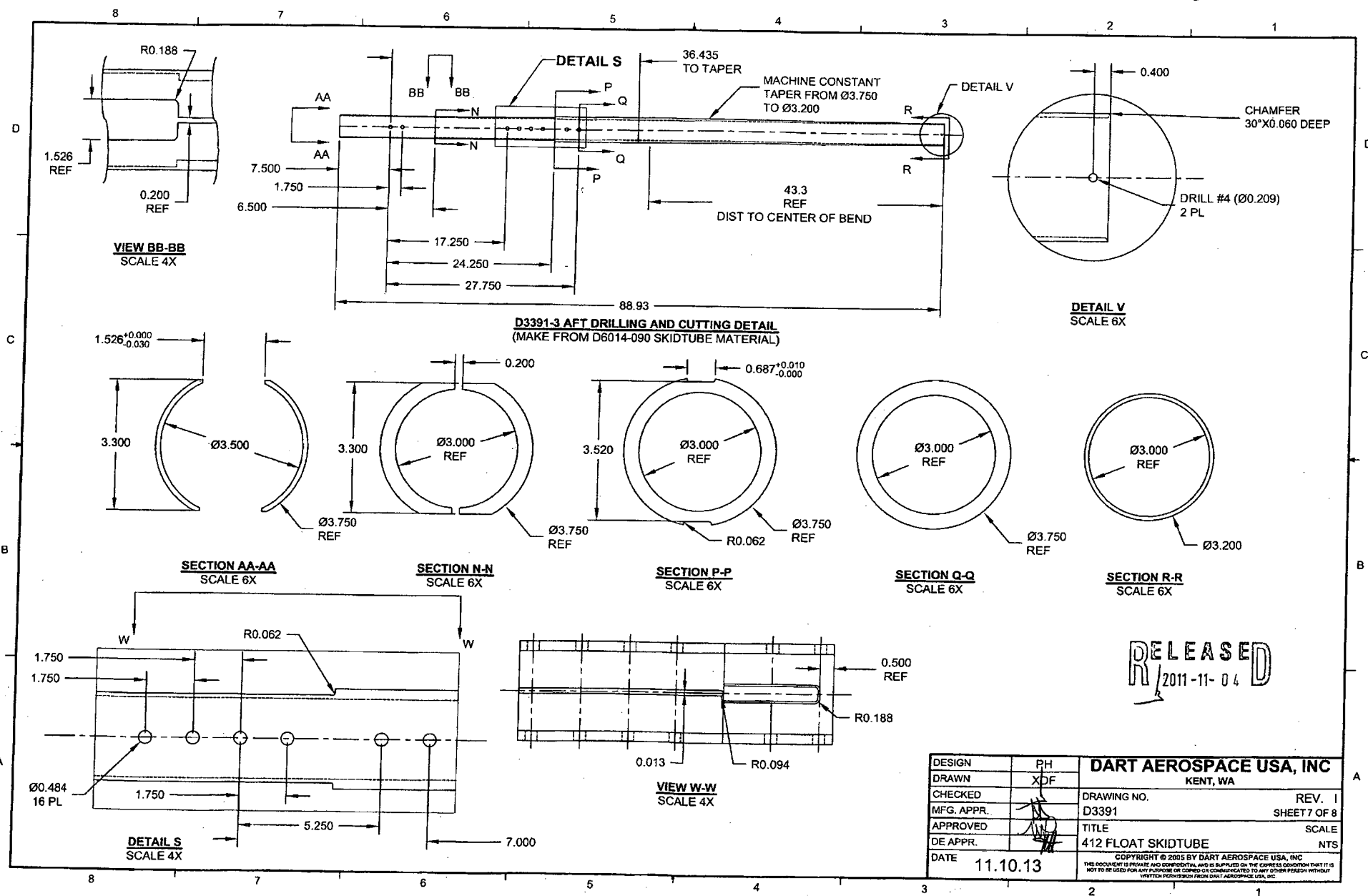
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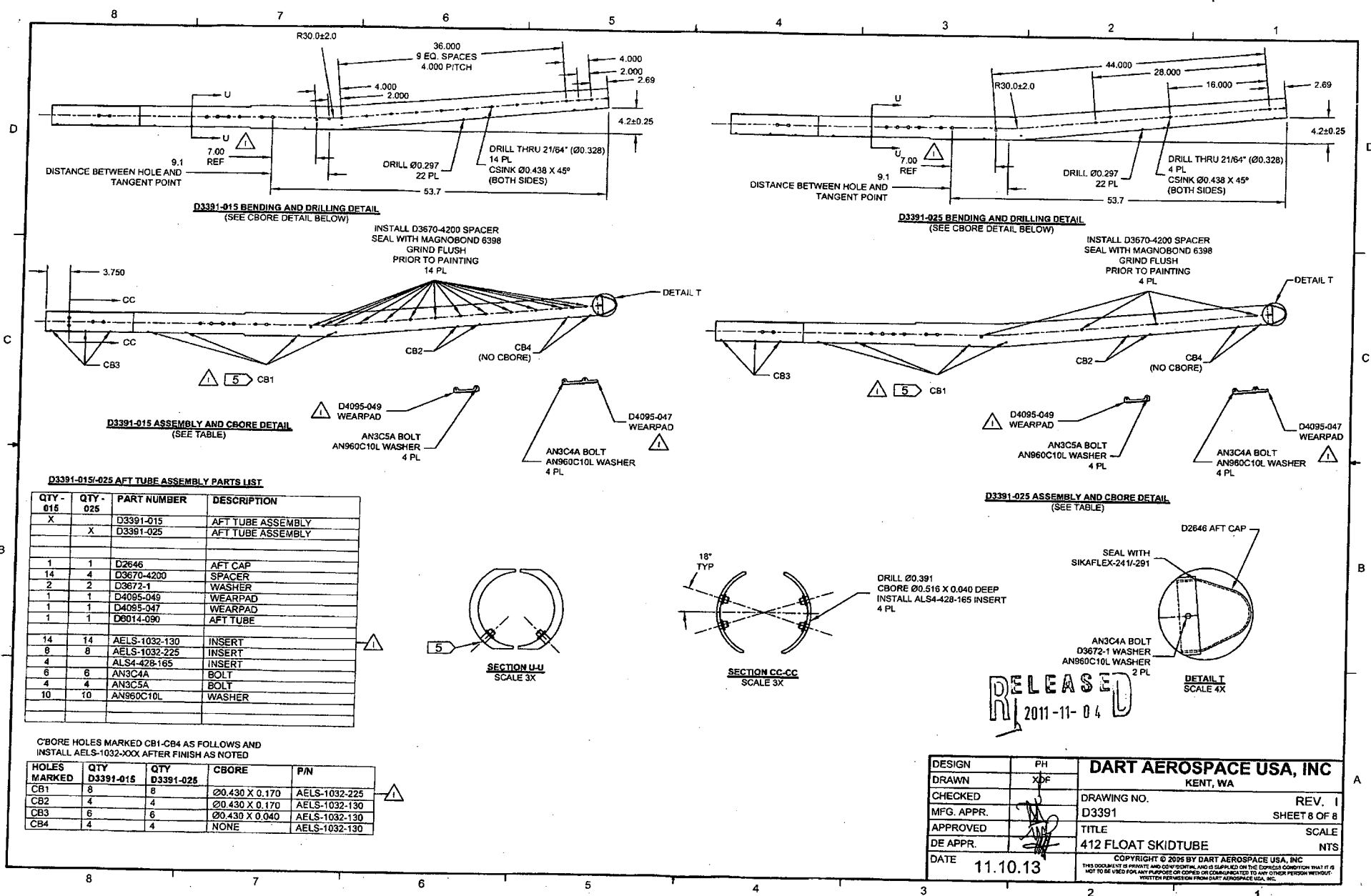
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